

Work Order ID 55457

Page 1

January 19, 2010 9:26:38 AM

Item ID: D3791-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 1/19/10 Start Qty: 12.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: *PL*Date: *10-1-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3791	Rev A
-------	-------

100



FLOW WATER JET

Waterjet

Memo

0.00

PL 10-1-25

FLOW CNC Waterjet

1-Cut as per Dwg D3791

Dwg Rev: *A*Prog Rev: *A**364 - 063*

2-Deburr if necessary

(12)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

PL 10-1-25

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

QC8- Inspect parts - second check

0.00

=> S 10/01/25

0.00

(12)

Quality Control

130



NC BRAKE

0.00

0.00

0.00

0.00

0.00

0.00

SB 10/01/28

Brake NC

Memo

Brake NC

1-Deburr if necessary

2-Form on Brake as per Dwg D3791 using Jigs

140



QC

QC5- Inspect part completeness to step on W/O

0.00

0.00

=> S 10/01/28

Quality Control

Memo

Ensure joggle as per dwg D3420

A/A

5

(12)

W/O:		WORK ORDER CHANGES					
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Customer:

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Large Fab

0.00

EL

10-2-1

(X12)

Large Fab

Memo

0.00

Large Fab

1-Weld hardcoat as per dwg D3791 QSI004

Hardcoat 2059b Batch: M113521

160



QC10- Inspect visual per QSI004- ground welds

0.00

=> S1002101

QC

Quality Control

(X12)

170



QC5- Inspect part completeness to step on W/O

0.00

=> S1002101

QC

Quality Control

(X12) f

W/O:		WORK ORDER CHANGES					
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Start Date: 1/19/10 Start Qty: 12.00



Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

0.00

0.00

M

10/02/10

(X12)

Q

Powder Coating

Memo

START TIME: 1:00pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 1:30pm

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

BK 10-02-11

(12)

200



Packaging

Identify as per dwg & Stock Location: FP-19

0.00

0.00

M 10/02/11

(X12)

Q

Memo

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

210

QC
Quality ControlOperation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/02/11 HJ

Memo

0.00

UMF 10-2-11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January 19, 2010 9:26:42 AM

Page 1

Work Order ID: 55457



Parent Item: D3791-1



Parent Item Name: Wearplate

Start Date: 1/19/10

Required Date: 1/25/10

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-22 revA as per dwg ECN1191 DD verified by:EC

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	260.9779	3.6846			



304/316 Sheet .063

1B 10-1-25

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	260.9778737	
106860	8.0295	
111924	25.1689737	
112442	29.8899	
113295	197.8895	1B 25

(12)

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DART AEROSPACE LTD	Work Order:	55457
Description: Wearplate	Part Number:	D3791-1
Inspection Dwg: D3791 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-2022	Date:	10/6/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

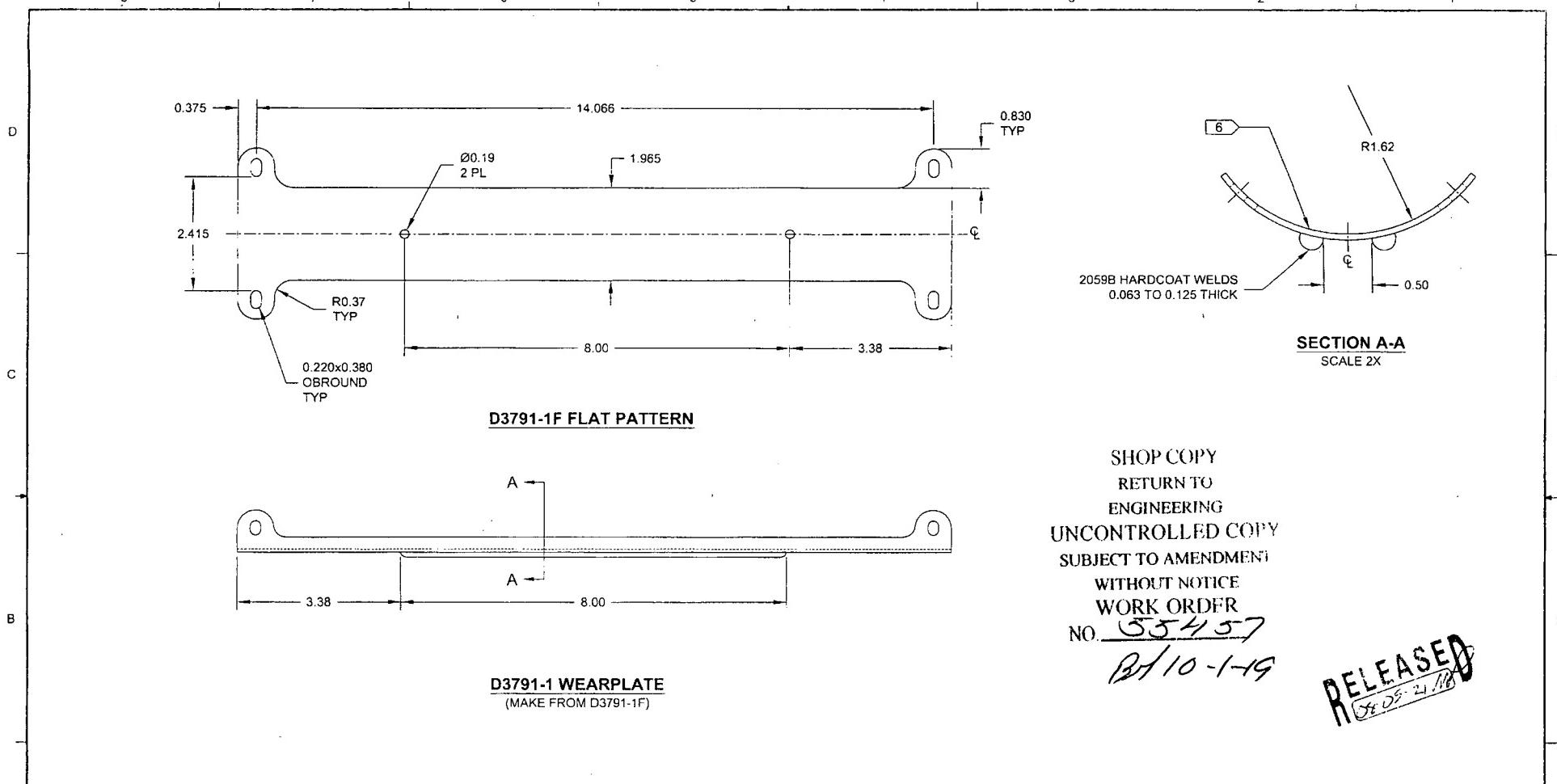
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3791-1" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.70 LBS
- 8) WELD PER DART QSI 004

A	NEW ISSUE	PH	08.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3791	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	08.05.13	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT'S NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55457
B10-1-19

RELEASED
08.05.21.18

W/O:		WORK ORDER CHANGES					
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